

Date: Monday, 29/09/2008 11:55:08 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SUPPORT
<b>Job Number</b> :	42320A		
<b>Estimate Number</b> :	10452		
<b>P.O. Number</b> :		<b>Part Number</b> :	D32781
<b>This Issue</b> :	29/09/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3278 REV. C
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	41346A	<b>Drawing Revision</b> :	C
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JUL 08.9.29</u>	<b>Due Date</b> :	10/10/2008
<b>Comment</b> :	Est:A 04.04.19 New issue KJ/JLM est B 07.09.06 rev.c dwg EC verified by: JLM		

Qty: 40 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.00 x 2.00



Comment: Qty.: 0.2454 f(s)/Unit Total: 9.8154 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: M/08877

L.A 08/10/12

2.0 SHEAR SHEAR



Comment: ~~SHEAR~~ BAND SAW

Cut blank: 2.00" x 1.00" x 2.550" long

L.A 08/10/12

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-1

28 08/10/20

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

28 08/10/20

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

28 08/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 29/09/2008 11:55:08 AM

User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 42320A

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL

08-10-20

(V40)

7.0

POWDER COATING

POWDER COATING



M109152



(40x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:45  
320 OF  
4:15

M-L

08/10/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL

08/10/21

(40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 80

SS

08/10/21

(X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/22

Job Completion



UMF 08-16-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42320A
<b>Description:</b> Support		<b>Part Number:</b> D3278-1
<b>Inspection Dwg:</b> D3278	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.0985				
0.359	+/-0.005	.362				
0.609	+/-0.010	.60				
0.250	+/-0.010	.250				
1.480	+/-0.005	1.480				
R0.125	+/-0.010	R.125				
0.119	+0.005/-0.004	.118				
2.439	+/-0.010	2.439				
1.980	+/-0.010	1.980				
R0.13	+/-0.030	R.13				
Ø0.257	+0.005/-0.000	.258				
R0.375	+/-0.010	R.375				
0.875	+/-0.010	.875				
0.500	+/-0.010	.500				
R0.400	+/-0.010	R.400				
R1.00	+/-0.030	R.1.0				
1.720	+/-0.010	1.720				
R0.125	+/-0.010	R.125				
0.125	+/-0.010	.125				

<b>Measured by:</b> RP	<b>Audited by:</b> SP	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/10/20	<b>Date:</b> 08/10/20	<b>Date:</b>	N/A

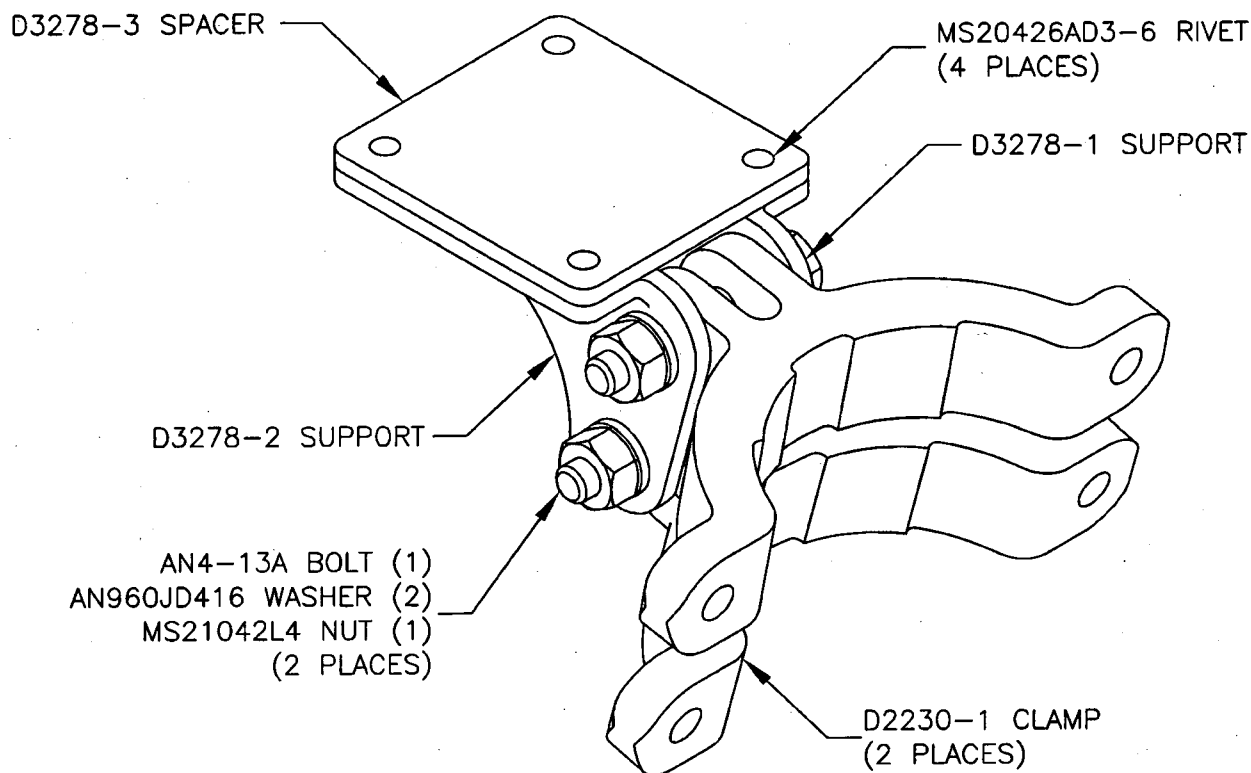
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	BE



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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
*07-08-18*

## D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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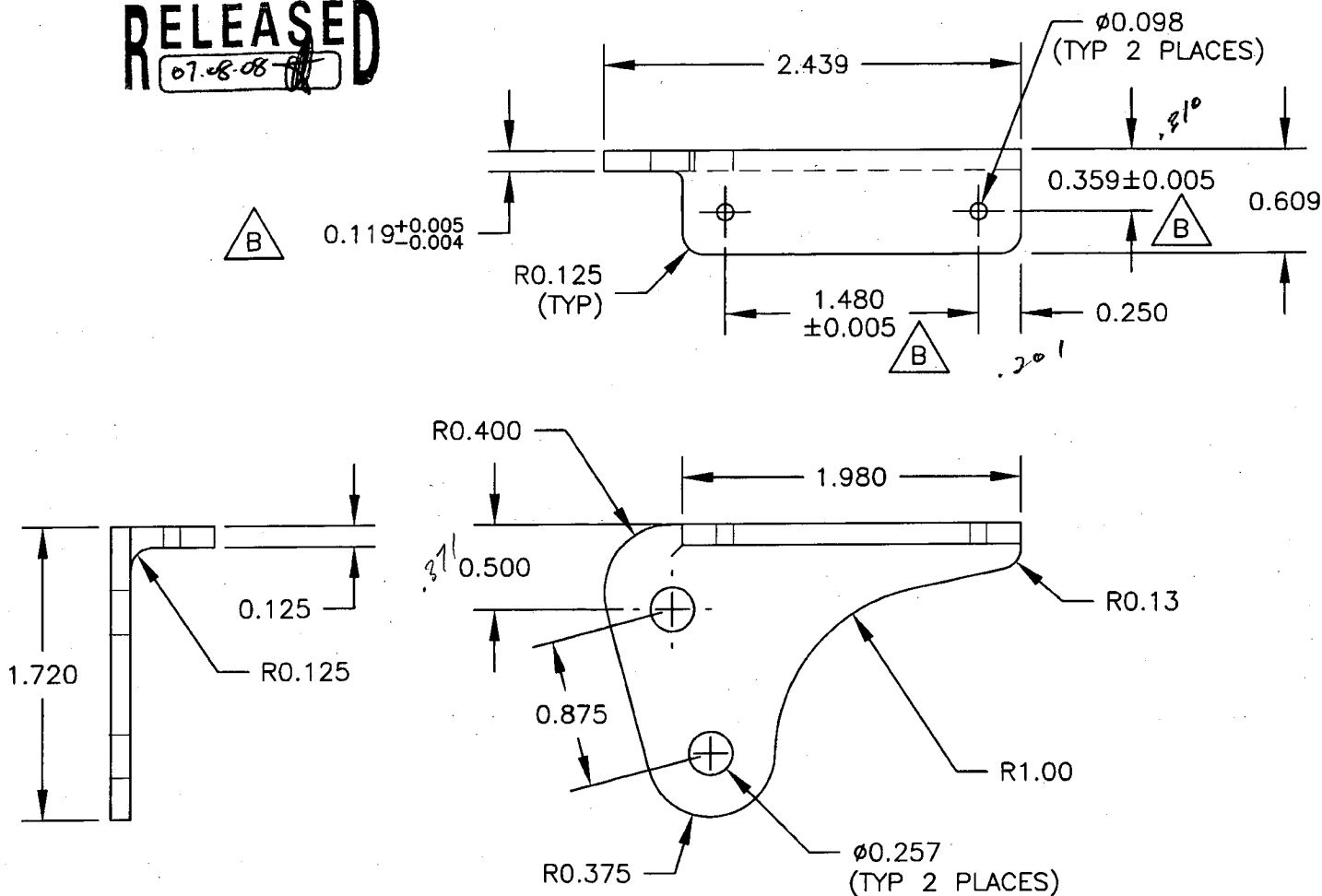
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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED  
07-08-08



**D3278-1 SUPPORT (SHOWN)**

**D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRJT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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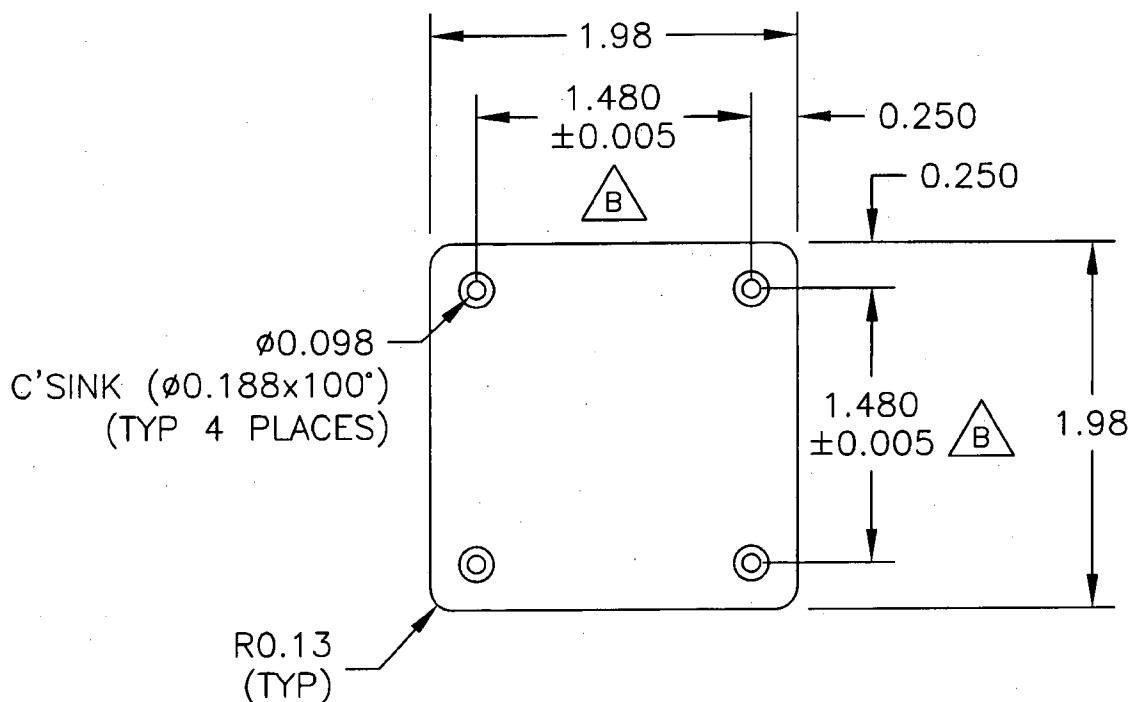
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CHECKED <i>JB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED  
07.08.08



**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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